

Date: Wednesday, 3/8/2006 10:37:45 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHROUD ASSEMBLY
Job Number : 26106	
Estimate Number : 12221	
P.O. Number :	Part Number : D34671
This Issue : 3/8/2006 S.O. No. :	Drawing Number : D3467 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run :	Material :
Written By : <u> </u>	Due Date : 3/31/2006 Qty: <u>29</u> Um: Each
Checked & Approved By : <u> </u>	
Comment : est rev. A 06.02.06 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting Issue P/O: 00000768
 Email or Ship DXF file to vendor
 Laser Cut per Dwg D3467 flat pattern D3467-1F
 Material release note required

06/03/09

2.0	D34671F	COVER PLATE FLAT PATTERN
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
 DOUBLER FLAT PATTERN

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

02-06-21 (20)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

02-06-22

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Deburr

2-Form as per dwg D3467

SB 06/03/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		Hole pattern Incorrect	ASD	Prototype check	18 06/03/07	18 06/03/07	18 06/03/07	18 06/03/07

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:37:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26106

Part Number: D34671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

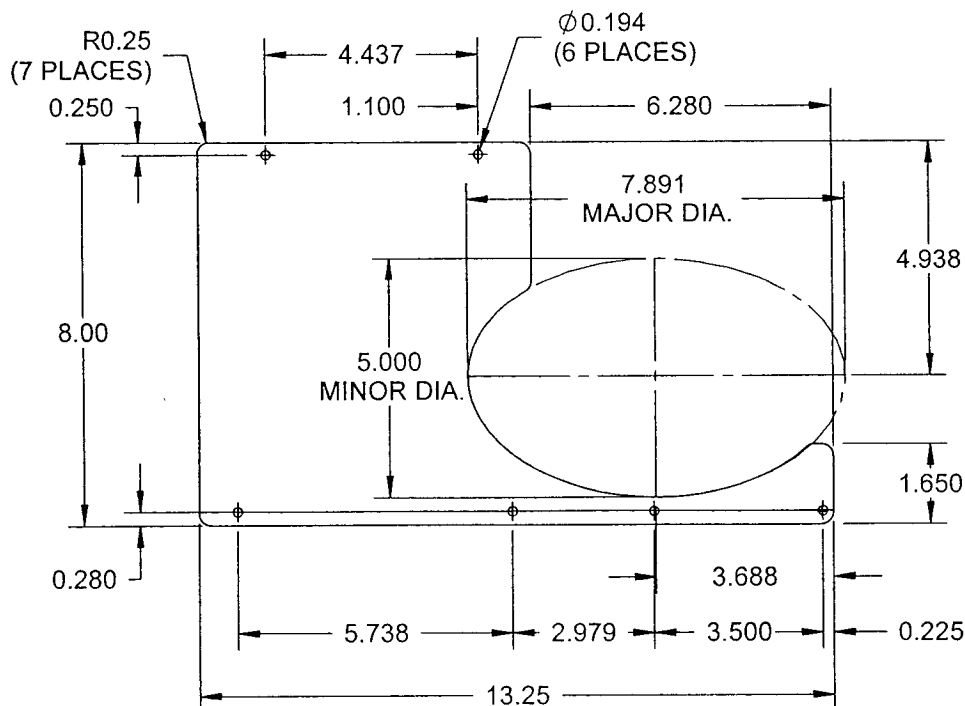
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

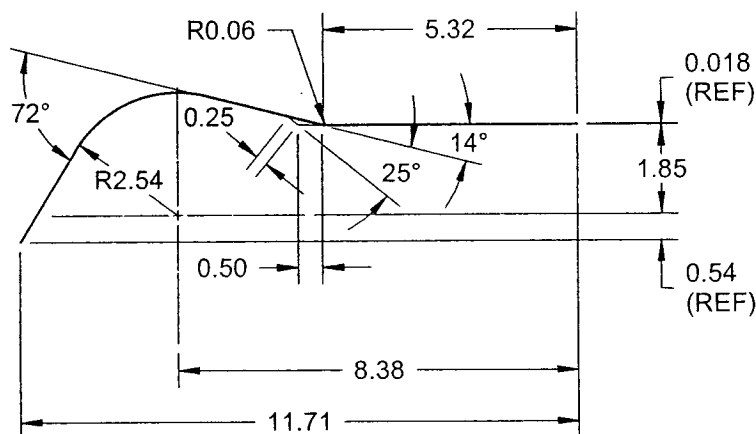
NOTE: Date & initial all entries

PRELIMINARY ISSUE

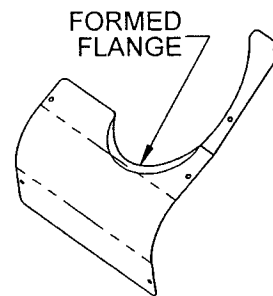
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3467	REV. A SHEET 6 OF 15
DATE 05.12.07	TITLE SHROUD ASSEMBLY		SCALE 1:4



D3467-1F COVER PLATE FLAT PATTERN



D3467-1 LH COVER PLATE
D3467-2 RH COVER PLATE (OPPOSITE)



D3467-1 LH COVER PLATE ISOMETRIC VIEW
D3467-2 RH COVER PLATE (OPPOSITE)
SCALE 1:8

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FINISH: ELECTRO CHEMICALLY POLISH
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

3/17/06
ATTN: JETE

604-946-4153

AK Steel		AK Steel Corporation		Page 1	
Metallurgical Test Report		Coastcon Works		Lead No. 710672	
Cashco, OH 43812				SERV No. 710672	
C O I L S T E E L		S H I P T O		BUYER'S ORDER NO. 42716-01	
INTEGRIS METALS PO BOX 40 MINNEAPOLIS, MN 5540		INTEGRIS METALS 306 B STREET ALBUQUERQUE, NM 87106		PROCESSOR ORDER NO. 42716-01	
PART NO. 710672		EXHAUSTION - PRODUCT - METRIC UNITS		PART NO. 710672	
T		118 NOM 40.000 X COIL		710672	
NET WEIGHT		NET WEIGHT		NET WEIGHT	
SK071313		SK071313		SK071313	
SK071314		SK071314		SK071314	
SK071315		SK071315		SK071315	
SK071316		SK071316		SK071316	
TOTAL SKIDS		TOTAL SKIDS		TOTAL SKIDS	
4		4		4	
L 710672		L 710672		L 710672	
C		C		C	
Mn		Mn		Mn	
P		P		P	
S		S		S	
SE		SE		SE	
CR		CR		CR	
Ni		Ni		Ni	
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CO		CO		CO	
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Mn		Mn		Mn	
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CR		CR		CR	
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Mo		Mo		Mo	
N		N		N	

Ryerson

3/17/2006 1:57

PAGE 002/002

Fax Server

MAY-17-2006 16:05

FROM-INTEGRIS

293-288-8833

T-726 P.008/015 F-537



AK Steel Corporation
Metallurgical Test Report
Construction Works
Coshocton, OH 43812

Page 2

Lot# No. 7410572
 BRN No. 7410672

WILL ORDER NO. PROCESSOR ORDER NO. BUTLER ORDER NO.
 471348-0191 427136-01 427136-01

INTEGRIS METALS
 PO BOX 390
 MINNEAPOLIS, MN 55440

INTEGRIS METALS
 308 "B" STREET
 AUBURN, WA 98001

PART NO. 7425107
 ENGLISH UNITS - PRODUCT - METRIC UNITS
 3715 N04 44600 X COIL

ITEM	QTY	UNIT
0	1	0

PARENT COIL	POS	DIR	COND	ASTM	BEND	TEST	ROCKWELL	ROCKWELL
ID	(W/D)	(L, T, D)		A 362	30			
056919-02	T		ASTM	PLATE	17			
PARENT COIL	POS	DIR	COND	3/16" LONG	25" OFFSET	74	72	74
ID	(W/D)	(L, T, D)		MEASURED	(KSI)			
056919-02	F	T	ASTM	71.0	92.0	33.1	B	B
PARENT COIL	POS	DIR	COND	BEND				
ID	(W/D)	(L, T, D)		17				
056919-02	F		ASTM	PLATE				

THIS CERTIFIED ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED HEREON ARE THE PROPERTY OF AK STEEL CORPORATION. NO PART OF THIS REPORT OR ANALYSIS OR TESTS SHALL BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF AK STEEL CORPORATION.

ALL TESTING IS DONE IN ACCORDANCE WITH ASTM STANDARDS UNLESS OTHERWISE NOTED

AK Steel Corporation

05/05/2006

THIS CERTIFIED ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED HEREON ARE THE PROPERTY OF AK STEEL CORPORATION. NO PART OF THIS REPORT OR ANALYSIS OR TESTS SHALL BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF AK STEEL CORPORATION.

REPRODUCED BY AK STEEL CORPORATION

05/05/2006

Steve Ryerson

DATE 05/05/2006 TIME 10:01 AM

AK STEEL CORPORATION

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K9
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 4TH STREET SE
CALGARY, AB T2C2Y3

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 415824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a 480/04a, 666/03, ASMESA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 1/8 FRM, AMS5513H X MRK&FIN, MIL5055D, AMD3, X CROWN MEAS
CORROSION: ASTM A262/02aE; 180Bend-OK
Buyer Part: 4288441
304 2B .1305 IN 48 IN 96 IN
Country of Origin: UNITED STATES

Mechanical Tests

		DOWN	L	O	DOWN	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV			
Tensile Strength (UTS)	93.3	KSI	F	TRANSV			
Rockwell B	85		F	TRANSV			
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV			
Rockwell A	85		T	TRANSV			

Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

Comments

1002
004
003/004

INDUSTRIAL LASER CUTTING
ANALYSIS METALS

03/17/2006 14:37 FAX 604 948 4153
04/20/2016 08:27 FAX

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 2
Heat/Lot : 86K8
TIN : B42748

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 QQS763F Cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

QA by ERIC HESS 02/01/2006

Miscellaneous Data

GUKLPH , ONN K123
Control #: 90C60214
Part #: 74271441
.135 X .48 X .96

Date: 03/17/06

SOLD TO: INDA LASH

TO 110880

S/O 90-374786 - 02

Edg 3/17/06

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.

INTEGRIS METALS, LTD.

